



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
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Canada

Tel (613) 632-5200
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007440

D4467-041
Job Sheet 187092



Part No: D4467-041

Job Qty: 1 pcs

Part Name: Lower Door Assembly, LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/27/18

Job Tracking No:

Due Date: 1/31/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV D-DEO SHEETS 1,2,3,4,5 IPP revA 11.12.21 new issue EC verified by:DD IPP revB 12.02.10 per PA3 EC verified by:DD IPP REV:C PER PB1 JLM VERIFIED BY:DD IPP Rev:D 12.10.09 per dwg revB DD VERF:JLM IPP REV:E 12.12.03 per dwg revC DD VERF:JLM IPP REV:F 13.02.11 PER DWG REV.D DD VERF:JLM IPP REV:G 15.08.27 PER DWG REV.D-DEO DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Packaging 1 - Pick Kit	1 pcs		1/31/19	0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		DAS
							Packaging 1 - 9		36
							Packaging 1 - 10		9-89
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER : _____			

					Packaging 1 - 31	
					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
110 Small Fab - 1	1 pcs	1/31/19	0.00	0.00	Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	DAS
					Small Fab - 5 - B4B	36
					Small Fab - 6 - B4B	9-89
					Small Fab - 7 - B4B	
120 QC 5	1 pcs	1/31/19	0.00	0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 16	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 38	
					QC 5 - 42	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	PD 18.02.29
					QC 5 - 50	
					QC 5 - 30	
130 Packaging 3-1 - Stock - B4B	1 pcs	1/31/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	DAS
					Packaging 3 - 9 - B4B	36
					Packaging 3 - 10 - B4B	9-89
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
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					Packaging 3 - 28 - B4B	
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				Packaging 3 - 30 - B4B	DAS FEB 20 2019 21 2-88
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
140 QC 21 - SA	1 pcs	1/31/19	0.00 0.00	QC 21 - SA - 16	

Part Op 100 - Pick Kit

Descriptions: 110 - Small Fab - Assemble as per dwg and install rivet wet using proseal (see note 8) Seal gaps with proseal as per dwg (see note 9) Coat both faces of D4469-1 skin locally using proseal prior to installation of D4759-1 scuff strip. (see note 10) Proseal 890 B-2 Batch: _____

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4469-1	Outer Skin Lower Door	1 pcs (1 ea)	100-Packaging 1 - Pick Kit	5151559
D4470-041	Aft Rib Assembly, LH	1 pcs (1 ea)	100-Packaging 1 - Pick Kit	F119880
D4471-041	Mid Rib Assembly, LH	1 Ea (1 ea)	100-Packaging 1 - Pick Kit	F122471
D4472-041	Fwd Rib Assembly, LH	1 Ea (1 ea)	100-Packaging 1 - Pick Kit	F119801
D4473-041	Small Rib Assembly, LH	1 Ea (1 ea)	100-Packaging 1 - Pick Kit	F122254
D4474-1	Splice Block	1 Ea (1 ea)	100-Packaging 1 - Pick Kit	F95471
D4475-041	Small Rib Assembly	1 Ea (1 ea)	100-Packaging 1 - Pick Kit	F84575
D4476-041	Small Rib Assembly, LH	1 Ea (1 ea)	100-Packaging 1 - Pick Kit	F123253
D4477-041	Small Rib Assembly	1 Ea (1 ea)	100-Packaging 1 - Pick Kit	F95478
D4478-041	Intercostal 1 Assembly, LH	1 Ea (1 ea)	100-Packaging 1 - Pick Kit	F121947
D4479-041	Intercostal 2 Assembly, LH	1 Ea (1 ea)	100-Packaging 1 - Pick Kit	F101846
D4481-041	Intercostal 4 Assembly, LH	1 Ea (1 ea)	100-Packaging 1 - Pick Kit	F121959
D4482-041	Intercostal 5 Assembly, LH	1 Ea (1 ea)	100-Packaging 1 - Pick Kit	F85002
D4483-041	Fwd Closeout Panel Assembly, LH	1 Ea (1 ea)	100-Packaging 1 - Pick Kit	5136330
D4484-041	Bottom Panel Assembly, LH	1 Ea (1 ea)	100-Packaging 1 - Pick Kit	F84492
D4484-043	Aft Bottom Panel Assembly, LH	1 Ea (1 ea)	100-Packaging 1 - Pick Kit	F134578
D4485-1	Lower Closeout Panel	1 Ea (1 ea)	100-Packaging 1 - Pick Kit	F95489
D4486-041	Access Panel Assembly, LH	1 Ea (1 ea)	100-Packaging 1 - Pick Kit	F121952
D4486-3	Fwd Access Panel, LH	1 Ea (1 ea)	100-Packaging 1 - Pick Kit	96083
D4487-041	Closeout Panel Assembly, LH	1 Ea (1 ea)	100-Packaging 1 - Pick Kit	F121941
D4488-5	Angle Clip	1 Ea (1 ea)	100-Packaging 1 - Pick Kit	F84446
D4490-1	Splice Plate	1 Ea (1 ea)	100-Packaging 1 - Pick Kit	F95492
D4490-3	Splice Plate	1 Ea (1 ea)	100-Packaging 1 - Pick Kit	F95493
D4494-041	Upper Block Assembly, LH	1 Ea (1 ea)	100-Packaging 1 - Pick Kit	F123252
D4521-1	Doubler Lower Door	1 Ea (1 ea)	100-Packaging 1 - Pick Kit	5153242
D4570-5	Bracket	1 Ea (1 ea)	100-Packaging 1 - Pick Kit	F86401
MS20426AD3-3	Rivet	54 Ea (54 ea)	100-Packaging 1 - Pick Kit	5018535-
MS20426AD3-4	Rivet	18 Ea (18 ea)	100-Packaging 1 - Pick Kit	F1136444-2-1
MS20426AD4-4	Rivet	3 Ea (3 ea)	100-Packaging 1 - Pick Kit	5113854
MS20426AD4-6	Rivet	38 Ea (38 ea)	100-Packaging 1 - Pick Kit	5093088
MS20426AD4-8	Rivet	4 Ea (4 ea)	100-Packaging 1 - Pick Kit	F18136-4
MS20470AD4-3	Rivet, Universal Head	74 Ea (74 ea)	100-Packaging 1 - Pick Kit	5080629
MS20470AD4-4	Rivet, Universal Head	20 Ea (20 ea)	100-Packaging 1 - Pick Kit	5106821-1
MS20470AD4-5	Rivet, Universal Head	22 Ea (22 ea)	100-Packaging 1 - Pick Kit	5134218
MS20470AD4-6	Rivet, Universal Head	1 Ea (1 ea)	100-Packaging 1 - Pick Kit	5131194
MS20601-AD4W3	Rivet	24 Ea (24 ea)	100-Packaging 1 - Pick Kit	5076850 F1130783-1
MS20615-3M3	Rivet	6 Ea (6 ea)	100-Packaging 1 - Pick Kit	F124859-40
MS21043-3	Nut	2 Ea (2 ea)	100-Packaging 1 - Pick Kit	5109966
MS21059L3K	Nutplate	9 Ea (9 ea)	100-Packaging 1 - Pick Kit	5131184
MS21069L08	Anchor Nut	1 Ea (1 ea)	100-Packaging 1 - Pick Kit	F123522-40
MS24694-S4	Screw	11 Ea (11 ea)	100-Packaging 1 - Pick Kit	F11788
MS24694-S5	Screw	7 Ea (7 ea)	100-Packaging 1 - Pick Kit	F19072
MS24694-S56	Screw	4 Ea (4 ea)	100-Packaging 1 - Pick Kit	F1137951-50
MS27039-08-07	Screw	2 Ea (2 ea)	100-Packaging 1 - Pick Kit	5044221
MS27039-1-07	Screw	3 Ea (3 ea)	100-Packaging 1 - Pick Kit	511086
MS27039-1-14	Screw	2 Ea (2 ea)	100-Packaging 1 - Pick Kit	F120449-40

DQA: _____ Date: _____



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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
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				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

NAS1149D0332J	Washer	7 Ea (7 ea)	100-Packaging 1 - Pick Kit
NAS1149DN832J	Washer	2 Ea (2 ea)	100-Packaging 1 - Pick Kit
D4759-1	Scuff Strip	1 Ea (1 ea)	140-QC 21 - SA

5113251
5131200
F1620504

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Packaging 1 - Pick Kit	D4469-1	1	1	0
	D4470-041	1	1	0
	D4471-041	1	0	0
	D4472-041	1	9	0
	D4473-041	1	5	0
	D4474-1	1	4	0
	D4475-041	1	7	0
	D4476-041	1	12	0
	D4477-041	1	8	0
	D4478-041	1	1	0
	D4479-041	1	6	0
	D4481-041	1	4	0
	D4482-041	1	2	0
	D4483-041	1	0	0
	D4484-041	1	2	0
	D4484-043	1	3	0
	D4485-1	1	3	0
	D4486-041	1	3	0
	D4486-3	1	10	0
	D4487-041	1	1	0
	D4488-5	1	1	0
	D4490-1	1	3	0
	D4490-3	1	3	0
	D4494-041	1	5	0
	D4521-1	1	3	0
	D4570-5	1	7	0
	MS20426AD3-3	54	3,580	0
	MS20426AD3-4	18	4,336	0
	MS20426AD4-4	3	2,961	0
	MS20426AD4-6	38	1,787	0
	MS20426AD4-8	4	2,371	0
	MS20470AD4-3	74	4,849	0
	MS20470AD4-4	20	3,883	0
	MS20470AD4-5	22	761	0
	MS20470AD4-6	1	1,528	0
	MS20601-AD4W3	24	537	0
	MS20615-3M3	6	1,679	0
	MS21043-3	2	886	0
	MS21059L3K	9	386	0
	MS21069L08	1	350	0
	MS24694-S4	11	42	0
	MS24694-S5	7	281	0
	MS24694-S56	4	105	0
	MS27039-08-07	2	258	0
	MS27039-1-07	3	185	0
	MS27039-1-14	2	375	0
	NAS1149D0332J	7	1,782	0
	NAS1149DN832J	2	1,967	0
	D4759-1	1	5	0
140-QC 21 - SA				

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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DART Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com DART AEROSPACE Container No: S155017 Part: D4467 - 041 Job No: 187092 Serial No/Batch: S155017 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 02/20/19				Completed By																																																																	
				Lead hand / Supervisor Approval Verification																																																																	
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